

Work Order ID 161379

Monday, May 15, 2017 11:16:21 AM

161379

Page 1

Item ID: D2654-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 5/15/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 5/17/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: **DAS** Date: **MAY 15 2017** Tooling: Date: Run Start ***NR1***
QC: **21** Date: SPC (Y/N): Date: Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2654	F

100

0.00

100

Skidtubes

Skidtubes

Memo

2.86

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654
3-Open holes to finish size as per Dwg D2654
4-Deburr holes and ends

6 MGG 17/05/16
DT

110

Chemical Conversion Coat per QSI005 4.1

0.00

110

HandFinish

Memo

1.96

Hand Finishing

(X6) 2017/05/31
BEB

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.12

Quality Control

6 BB
17-06-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.06				6	0	17-06-05	BE
Quality Control									
140	Identify as per dwg & Stock Location	0.00							
140									
Packaging	Memo	0.06				6	0	17-06-05	BE
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.60							17/6/7
Quality Control									

 JUN 02 2017

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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

Monday, May 15, 2017 11:16:24 AM

Page 1

Work Order ID: 161379

161379

Parent Item: D2654-7

D2654-7

Parent Item Name: Web

Start Date: 5/15/2017

Required Date: 5/17/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM
IPP Rev:e 06.04.05 Added level21 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140		Manufactured	No			100	Each	35.0000	1	6			
D2600-7-140									**				
EXT. "I BEAM" THICK													

MGG 17/05/16

Location

Loc Qty

Loc Code

HALL

26

148586

26

LG

9

131525

9

6

DQA: _____ Date: _____

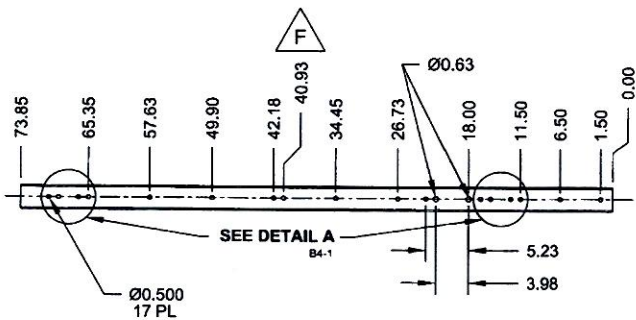
WORK ORDER NON-CONFORMANCE / UPDATE



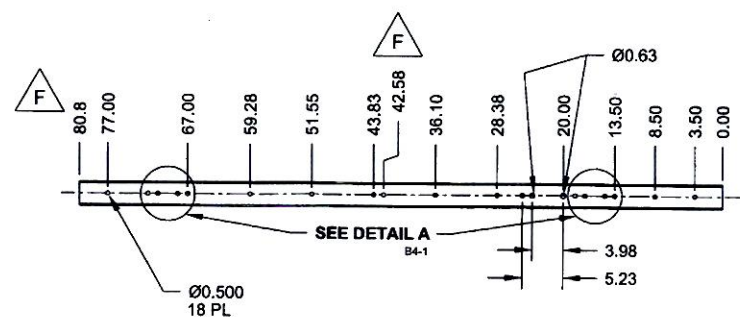
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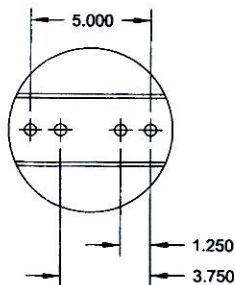
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Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161228 MWS
1705-15

RELEASED
2011-09-12
M

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2		SC	11.05.05
E	CHANGE LENGTHS, REFORMAT		CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63		CP	98.01.15
C	CHANGED HOLE PATTERN		CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438		CP	97.06.26
A	NEW ISSUE		CP	97.03.25
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	SC			
CHECKED	CP			
MFG. APPR.	CP			
APPROVED	CP			
DE APPR.	CP	REV. F		
DATE	11.05.05	SHEET 1 OF 2		
		SCALE		
		NTS		
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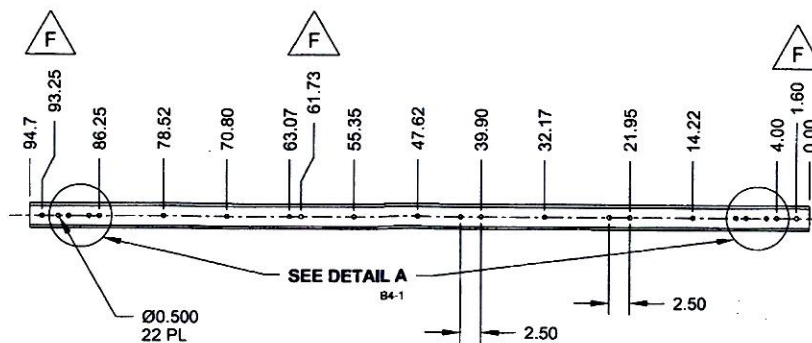


WORK ORDER NON-CONFORMANCE / UPDATE

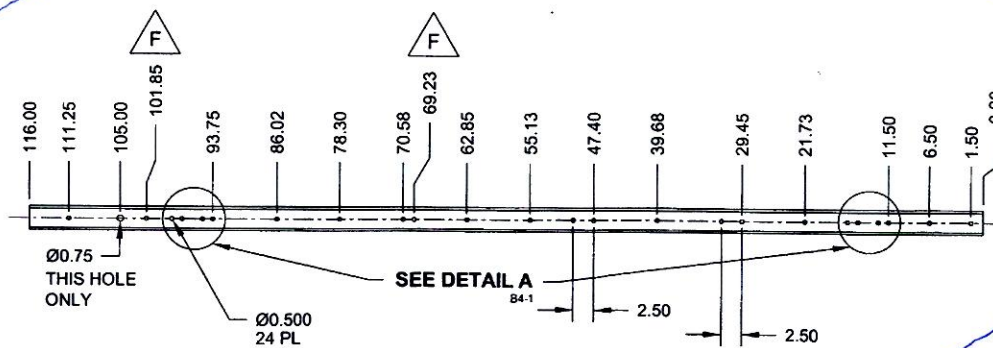
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OTHER : ☐																									



D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. F
MFG. APPR.	97	D2654	SHEET 2 OF 2
APPROVED	97	TITLE	SCALE
DE APPR.	97	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

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